

other holes drilled from the same side must be drilled perpendicularly to the faces of the work, it would not be of advantage to plane the feet so that the hole *A* could be drilled in the manner previously shown in Fig. 12. Therefore the feet are left to suit the perpendicular holes, and the separate base bracket *B*, Fig. 13, is used to hold the jig in the desired inclined position when the hole *A* is drilled.

Stand *B* in Fig. 13 is very suitable for this special work. It is made up as light as possible, being cored at the center, so as to remove superfluous metal. These stands are sometimes pro-

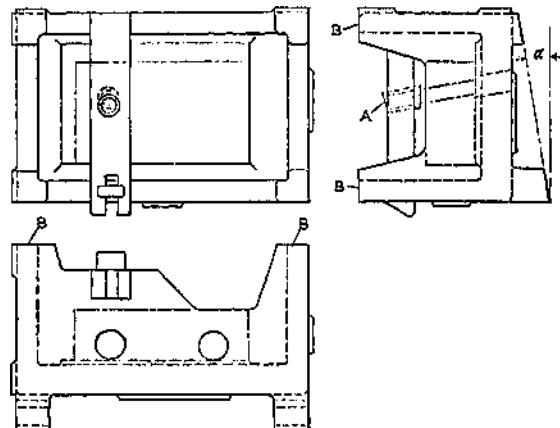


Fig. 12. Jig for Drilling Holes at an Angle

vided with a clamping device for holding the jig to the stand. Special stands are not only used for drilling holes at angles with the remaining holes to be drilled, but sometimes such stands are made to suit the jig in cases where it would be inconvenient to provide the jig with feet, finished bosses, or lugs, for resting directly

on the drill-press table.

When a jig of large dimensions is to be turned over, either for the insertion or removal of the work, or for drilling holes from opposite sides, it is, in cases where the use of a crane or hoist can be obtained, very satisfactory to have a special device attached to the jig for turning it over. Fig. 14 shows such an arrangement. In this illustration, *A* represents the jig which is